

Date  
UserFriday, 15/08/2008 11:03:31 AM  
Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : BRACKET

Job Number : 41256

Estimate Number : 13292

P.O. Number :

This Issue : 15/08/2008

S.O. No. :

Prsht Rev. : NC

First Issue : / /

Type : SMALL / MED FAB

Previous Run : 39033

Part Number : D37853

Drawing Number : D3785 PRELIM

Project Number : N/A

Drawing Revision : PRELIM

Material :

Due Date : 15/08/2008

Qty: 2 Um: Each

Written By :

Checked &amp; Approved By :

Comment : Est Rev:A 08-05-01 new issue DD verified by:EC

## Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S080

0.125

6061-T6 .080 Sheet



106634

HB 8-8-18



Comment: Qty.: 0.2333 sf(s)/Unit Total: 0.4666 sf(s)

6061-T6 .080 Sheet

0.125

106634

HB 8-8-15



2.0

WATER JET



106633

HB 8-9-3



Comment: FLOW WATER JET

1-Cut as per Dwg D3785

Dwg Rev: PREL

Prog Rev: PREL

\*\*\*\*grain direction along 3.60\*\*\*\*

2- Deburr if necessary

HB 8-8-18

HB 8-9-3



HB 8-8-15

HB 8-8-18

HB 8-9-3

3.0

QC2



INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-8-15

HB 8-8-18



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-9-3

4.0

QC8



SECOND CHECK

016-08-18



Comment: SECOND CHECK

3

5.0

BRAKE NC



NC BRAKE

2.040



Comment: NC BRAKE

Bend as per Dwg D3785

SB 08/08/25



## Process Sheet

R001 Dart Helicopters Services

Drawing Name: BRACKET

41256

Part Number: D37853



Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-counter sink holes as per dwg D3785

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
REFERENCE ONLY  
APPROVALENGINEERING  
APPROVAL

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FOR ENGINEERING USE ONLY

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

FOR ENGINEERING USE ONLY



Wm. 320 2014 2014 2014

# Process Sheet

001 Dart Helicopters Services

Drawing Name: BRACKET

,1256

Part Number: D37853



Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

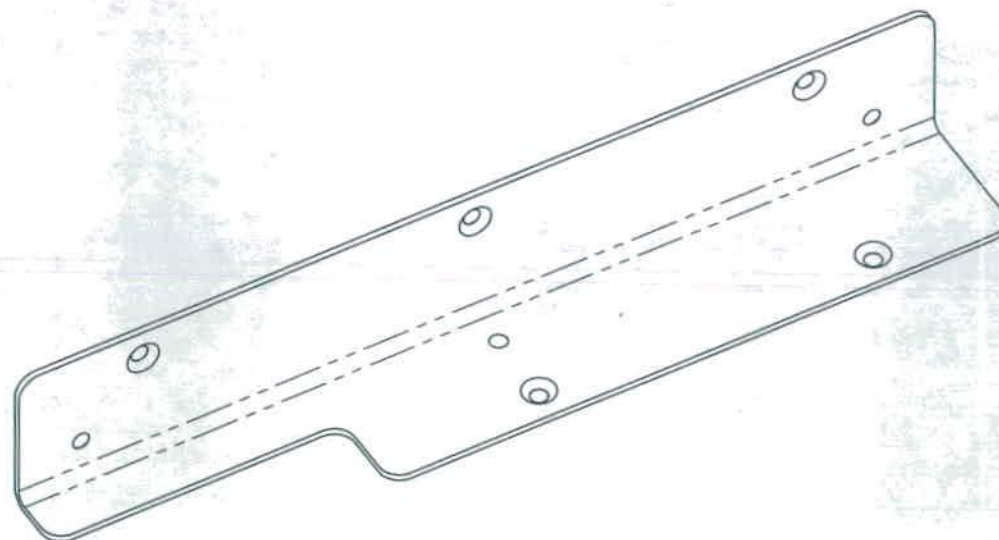












**D3785-3 BRACKET**

**NOTES:**

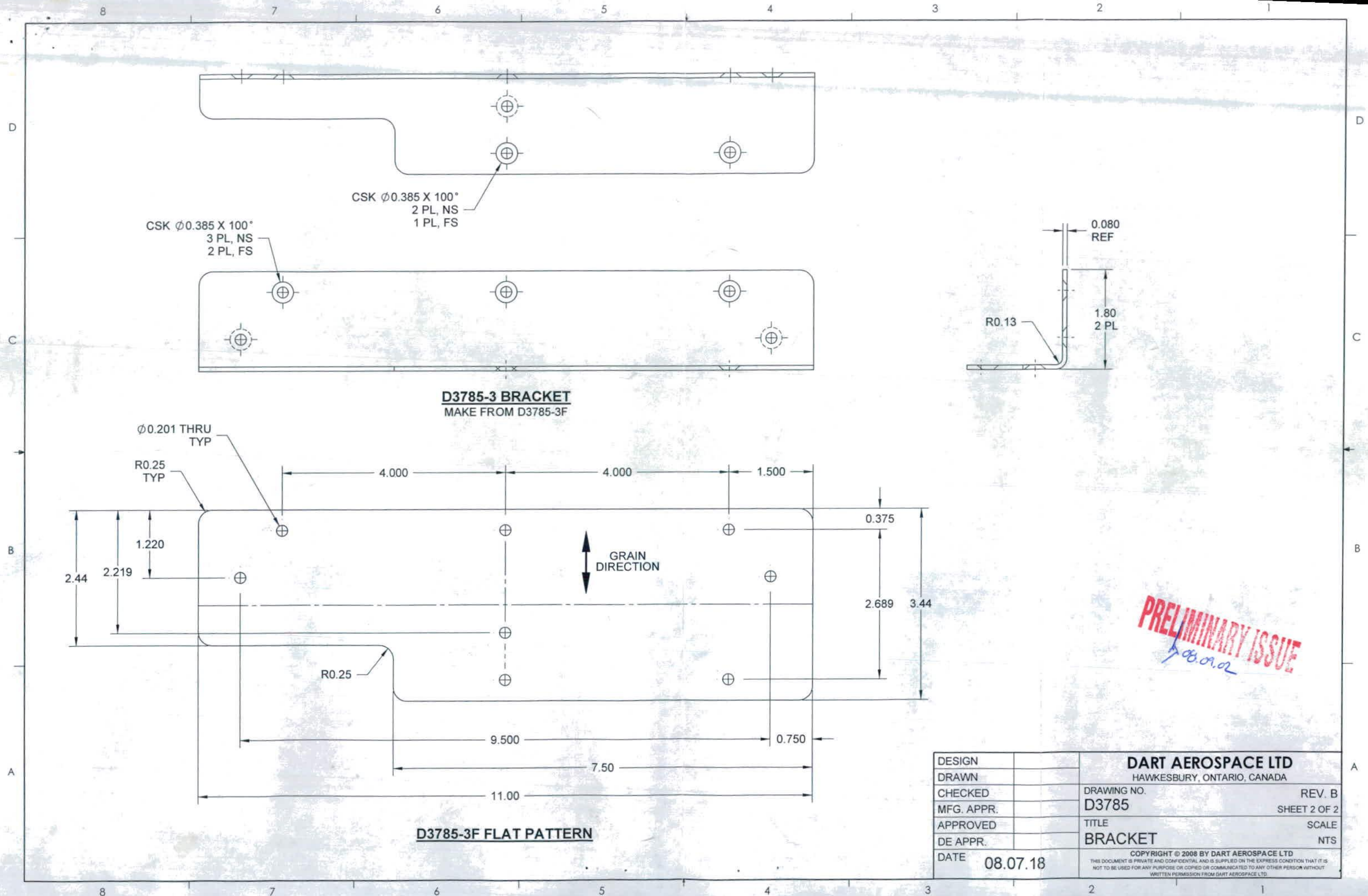
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

**PRELIMINARY ISSUE**  
5/26/07

B	REDESIGNED D3785-3; REMOVED P/Ns D3785-041/-1/-5/-7; DRAWING TITLE WAS ARMREST WELDMENT REASON: ELIMINATED ARMREST FWD-AFT ADJUSTMENT; PARTS AND WELDMENT NO LONGER REQUIRED	MB	08.07.18
A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3785	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	08.07.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



РЕГИСТРАЦИЯ





BEHIND THE SCENES